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RBST2812-P
Job Sheet 182150



9-06

Part No: RBST2812-P

Job Qty: 1 ea

Part Name: Portable Tri-Roller Staking Tool



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/19/18

Job Tracking No:

Due Date: 9/6/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBST2800-P Rev. 1 IPP Rev. A 18.06.21 new issue DP Verify DD

Ship Via:

DAS
13
9-89

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		9/6/18	0.00	0.00	Start Up Small Fab-4		MLL
100	Small Fab	1 pcs		9/6/18	0.00	0.50	Small Fab-9		MLL DAS
110	QC	1 pcs		9/6/18	0.00	0.00	QC5		38
130	Packaging	1 pcs		9/6/18	0.00	0.00	Packaging3-2		MLL 9-89
140	QC21-FG	1 Ea		9/6/18	0.00	0.00	QC21		DAS NOV 14 2018

Part Op 100 - 1-Assemble as per DWG sheet 1. ***NOTE*** - Apply a light coat of corrosion prevention compound to assembly
Descriptions: (LPS 1/2) See deviation. See note 1 and 2.
130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBST2812-P-3	Retainer	1 Ea (1 ea)	90-Start up Operation	5119966
92383A202	Roll Pin	1 pcs (1 ea)	100-Small Fab	
95065A150	Distorted Thread Lock Nut	1 pcs (1 ea)	100-Small Fab	5089124
99142A410	Internal Snap Ring	1 pcs (1 ea)	100-Small Fab	5089130
CS075-H1	Crest to Crest Flat Wire Wave Spring	1 Ea (1 ea)	100-Small Fab	5093424
NTA-411	Bearing	1 Ea (1 ea)	100-Small Fab	5035598
NTA-613	Bearing 13/16" Od X 3/8" Id (Applied)	1 Ea (1 ea)	100-Small Fab	5071979
RBST2812-P-1	Base	1 Ea (1 ea)	100-Small Fab	5121008
RBST2812-P-11	Dual Seat	1 Ea (1 ea)	100-Small Fab	5122412
RBST2812-P-13	Receiver	1 Ea (1 ea)	100-Small Fab	5121969
RBST2812-P-15	Tensioner	1 Ea (1 ea)	100-Small Fab	5122415
RBST2812-P-5	Roller	3 Ea (3 ea)	100-Small Fab	5114669
RBST2812-P-7	Cap	1 Ea (1 ea)	100-Small Fab	5114684
RBST2812-P-9	Stud	1 Ea (1 ea)	100-Small Fab	5122419
TRA-411	Washer	2 Ea (2 ea)	100-Small Fab	5035597
TRA-613	Washer 13/16" Od X 3/8" Id (Applied)	2 Ea (2 ea)	100-Small Fab	5070538

10
2
3

10
33
30

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBST2812-P-3	1	0	0
100-Small Fab	92383A202	1	100	0
	95065A150	1	100	0
	99142A410	1	50	0
	CS075-H1	1	10	0
	NTA-411	1	45	0
	NTA-613	1	15	0
	RBST2812-P-1	1	0	0
	RBST2812-P-11	1	0	0
	RBST2812-P-13	1	0	0
	RBST2812-P-15	1	0	0
	RBST2812-P-5	3	0	0
	RBST2812-P-7	1	0	0
	RBST2812-P-9	1	0	0
	TRA-411	2	79	0
	TRA-613	2	10	0

Part Specifications

Specifications could not be found.

Plex 9/6/18 8:47 AM dart.logan.david



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Container No: S127263



Part: RBST2812 - P

Job No: 182150

Serial No/Batch: S127263

Revision: 1

Inspector:

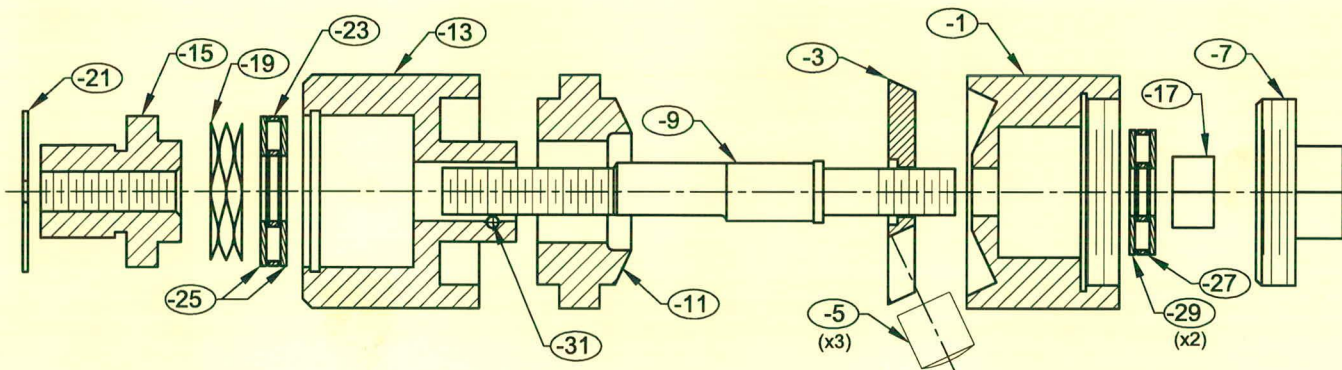
Exp Date:

Instructions:

Date: 11/13/18

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1	CH'D -1, -3, -9 -11 & -13 DATUM TARGET DESIGNATIONS AND FEATURE CONTROL FRAMES. ADDED 2ND FLAT ON -13.	7/26/12	RJC
			SE



NOTES

- 5 ROLLERS AND -3 RETAINER MUST TURN SMOOTHLY ON -1 BASE WHEN ASSEMBLED.
- FLAT END OF -5 ROLLERS MUST FACE THE CENTER OF TOOL WHEN ASSEMBLED.

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MAT.	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	BASE		SEE CHART	2
			-3	1	RETAINER		SEE CHART	3
			-5	3	ROLLER		SEE CHART	4
			-7	1	CAP		SEE CHART	5
			-9	1	STUD		SEE CHART	6
			-11	1	DUAL SEAT		SEE CHART	7
			-13	1	RECEIVER		SEE CHART	8
			-15	1	TENSIONER		SEE CHART	9
		B/O	-17	1	DISTORTED THREAD LOCK NUT	STEEL	1/4-20 UNC x 7/32 Ht. MCMMASTER-CARR #95065A150	1
		B/O	-19	1	CREST TO CREST FLAT WIRE WAVE SPRING	STEEL	.750 OD., .550 ID., WIRE THICK. .013, THREE TURNS SMALLEY RING CO. #CS075-H1	1
		B/O	-21	1	INTERNAL SNAP RING	STEEL	Ø7/8 BORE MCMMASTER-CARR #99142A410	1
		B/O	-23	1	THRUST BEARING (SPRING SIDE)	STEEL	Ø3/8 ID. x 13/16 OD. x 5/64 WIDTH APPLIED (TIMKEN #NTA-613)	1
		B/O	-25	2	BEARING WASHER	STEEL	Ø3/8 ID. x 13/16 OD. x 1/32 WIDTH APPLIED (TIMKEN #TRA-613)	1
		B/O	-27	1	THRUST BEARING	STEEL	Ø1/4 ID. x 11/16 OD. x 5/64 WIDTH APPLIED (TIMKEN #NTA-411)	1
		B/O	-29	2	BEARING WASHER	STEEL	Ø1/4 ID. x 11/16 OD. x 1/32 WIDTH APPLIED (TIMKEN #TRA-411)	1
		B/O	-31	1	ROLL PIN	STEEL	Ø3/32 x 3/8	N/S

BEARINGS & TOOLS COVERED

BEARING #	TOOL #
206-010-470-101	RBST2812-P

RED BARN MACHINE

TITLE RBST2800-P SERIES FOR BELL BEARINGS
PORTABLE TRI-ROLLER SWAGING TOOLS

DWG NO.	SEE CHART ABOVE FOR TOOL No.	REV	1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			
TOLERANCES ON:			
DECIMALS	XXX ± .005	FRACTIONS ± 1/32	
XX ± .01		ANGLES ± 5°	
X ± .1			
UNLESS OTHERWISE SPECIFIED			
1. BREAK ALL SHARP EDGES			
.015 x 45° PR .015 R			
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE	NTS	DATE	11-9-09
		SHEET	1 of 9

DRAWN BY: PERRITT
APPROVED: *D. W. Pitt*
HEAT TREAT FINISH
SPEC
USED ON BEARING
SEE CHART

